

Work Order ID 155447-1

155447

Page 1

Monday, January 16, 2017 11:13:23 AM

Item ID: D3801-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Hand Retractable Spring Plunger

Stop *NS2*

Start Date: 1/18/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/1/2017 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

DAS

Date: JAN 16 2017

Tooling:

Date:

QC:

21

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3801

B

100

0.00

100

PURCHASING

12 JAN 17 2017

DAS
13
3-89

Purchasing

Memo

0.00

Purchasing

Issue P/O:

34994

Purchase Part Number: KBP-504

Supplier: Essentra

Certificate of conformity is required

110

0.00

110

Receive & Inspect for Damage & Mat'l Certs

6x SPH-01-24

Packaging

Memo

0.04

Packaging

Ensure material certification is attached

120

0.00

120

QC6- Inspect dimensions to drawing

Ce

DAS
38
3-89

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D3801

JAN 25 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By _____	
				Lead hand / Supervisor Approval Verification _____	
				QC / QA Coordinator Approval _____	

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

Work Order ID 155447***155447***

Page 2

Monday, January 16, 2017 11:13:23 AM

Item ID: D3801-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hand Retractable Spring Plunger

Start Date: 1/18/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/1/2017 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 2054

0.00

130

Packaging

Memo

0.02

Packaging

6
DAS 6 21 9-89 JAN 27 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.20

Quality Control

17/01/30 98

DAS 21 9-89 JAN 27 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Monday, January 16, 2017 11:13:27 AM

Page 1

Work Order ID: 155447

155447

Parent Item: D3801-1

D3801-1

Parent Item Name: Hand Retractable Spring Plunger

Start Date: 1/18/2017

Required Date: 2/1/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-07-22 new issue DD verified by:EC
12.03.06 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

KBP-504

Purchased

No

110

Each

0.0000

1

12

KRP-504

Hand Retractable Spring Plunger

**

6x 12
6x Sp 17-01-24

DQA: _____ Date: _____



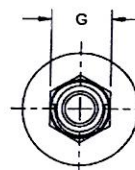
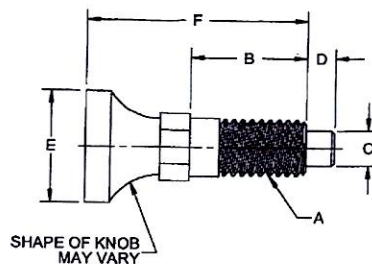
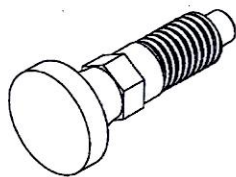
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155447 MJS
170116

D3801-X HAND RETRACTABLE SPRING PLUNGER

DART P/N	SUPPLIER	SUPPLIER P/N	'A' THREAD SIZE	'B' THREAD LENGTH	'C' NOSE DIAMETER	'D' NOSE LENGTH	'E' HEAD DIAMETER	'F' LENGTH	'G' WIDTH ACROSS FLATS	MATERIAL (BODY/ NOSE)	MATERIAL (KNOB)	TYPE	END FORCE (lbs)	WEIGHT (lbs)
D3801-1	REID SUPPLY COMPANY	KBP-504	3/8-24 UNF	0.67	0.197	0.20	0.83	1.71	0.50	303 SS	BLACK DELRIN	NON-LOCKING	2.7	0.01
D3801-3	REID SUPPLY COMPANY	PRT-22 OR PRT-22N	1/2-13 UNC	1.00	0.313	0.25	1.00	1.90	0.52	303 SS	WHITE DELRIN	NON-LOCKING	1.75	0.02

△

△

- NOTES:
1) MATERIAL: SEE TABLE
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

LEASED
2012-03-02

B	SUPPLIER P/N CHANGED: BODY/NOSE MAT'L WAS STEEL NOW STAINLESS STEEL. REF. CAR12-88		MB	12.02.24
A	NEW ISSUE		MB	08.06.19
REV.	DESCRIPTION		BY	DATE
DESIGN	DRAWING NO. D3801		REV. B	
DRAWN	HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 1	
CHECKED	TITLE		SCALE	
MFG. APPR.	HAND RETRACTABLE SPRING PLUNGER		NTS	
APPROVED	DATE 12.02.24		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DE APPR.	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34994**

Purchase Order Date 1/17/2017

PO Print Date 1/17/2017

Page Number 1 of 2

Order From :
ESSENTRA COMPONENTS
P.O. BOX 9900 T-9915
POSTAL STATION A
TORONTO, ONTARIO M5M 2J2
CANADA

VC-ESS001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

JAN 18 2017

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via: FedEx Economy collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	KBP-504 AS PER DWG D3801 REV. B B155447 DAS 38 9-89	Hand Retractable Spring Plunger	1/24/2017 Yes 1/24/2017		12.00 Each	\$24.46	\$293.52
Line Total:							\$293.52
2	71401-45	PROCUREMENT QUALITY CLAUSES	1/24/2017 No 1/24/2017		1.00	\$0.00	\$0.00
Procurement Quality Clauses A004 FAA-PMA /TSO A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A024 PROCESS CERTIFICATIONS A025 CERTIFICATE OF CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS							

Note:

1/17/2017

88 H-24-24



Essentra Components
2538 Speers Road, Unit 7
Oakville, ON L6L 5K9
Phone: 905-825-0134
Fax: 905-825-2919
www.essentracomponents.com

Packing List
LOAD NUMBER 559285
SID/INV 1524539
CUSTOMER PO PO34994
ORDER NUMBER 2278116
CARRIER Fed Ex Ground
SHIP DATE 01/20/17
FOB DESCRIPTION COL

SOLD TO 422854
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

DELIVERY TO 422854
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

LINE NO	PART NO. DESCRIPTION	ORIGINAL QUANTITY	QUANTITY SHIPPED	CTNS	NET WEIGHT	TOTAL WEIGHT
1	KBP-504 ✓ 3/8-24 NON-LOCKING SS PULL INDEXING PLUNGER Cust Order #: PO34994 Country Of Origin: DE FED EX ACCT # 1517-9324-0	12.000	6.000 ✓	1	.28	1.28

SP17-0-24

DAS
38
3-89

Certificate of Compliance

This is to certify that the above material shipped against your purchase order is in conformance with all known requirements, specifications and drawings in effect at the time of manufacture. All applicable physical, functional, dimensional and material test reports are on file at our facility, and may be inspected by your representative upon request.

Richard Queer
Quality Assurance Manager